

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03912

SHEET 1 L

DWG NO. 646.9700 REV: N/C PREPARED BY: J. BECKER DATE: 06/06/13 EFFECT ☒ INC. ☐ L.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY: *[Signature]* ENGR: *[Signature]* MFG: *[Signature]* QC: *[Signature]* EFF: *[Signature]* NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

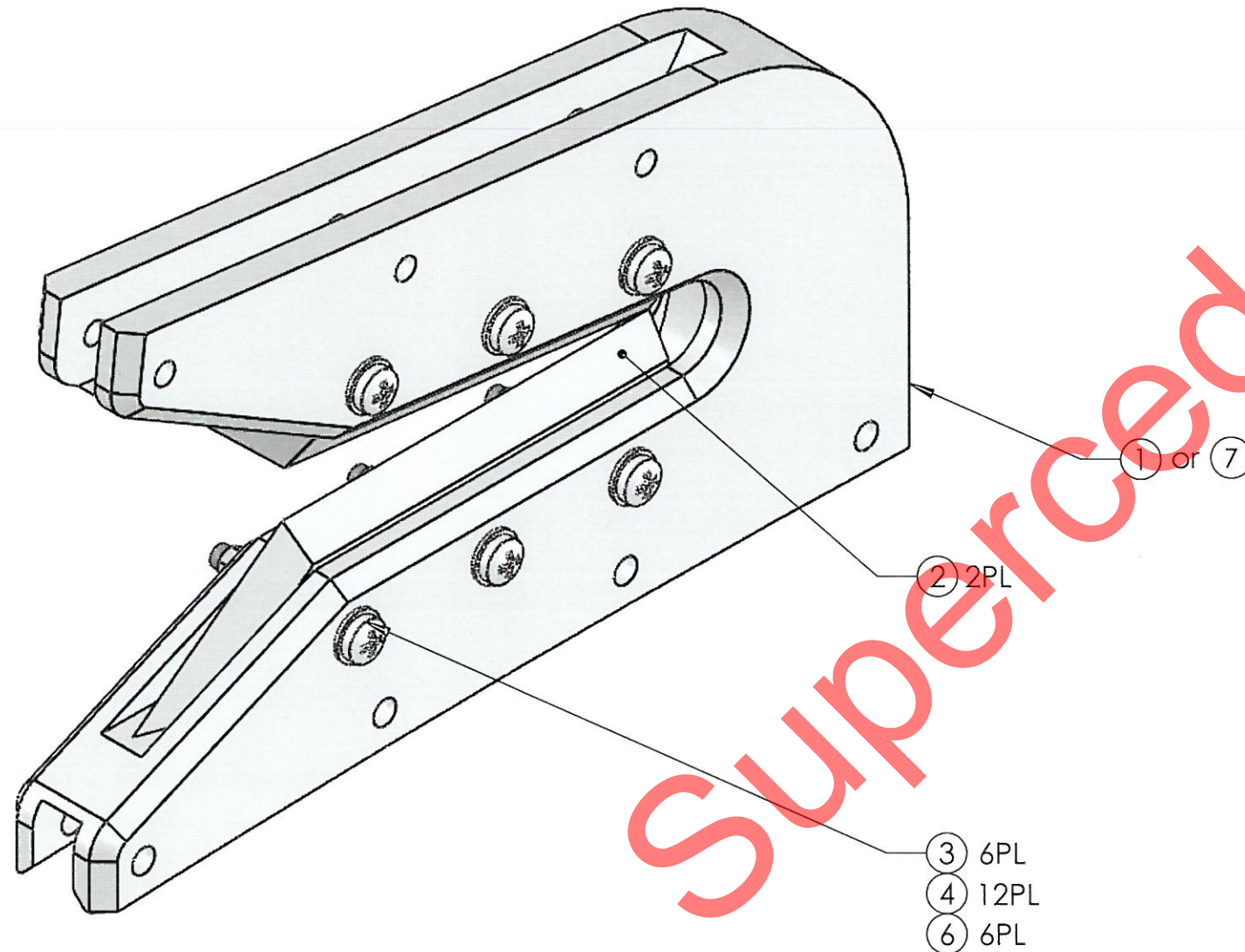
REASON: ADDED NOTE 9, ADDED SHEET 6, INCORPORATED
ECN'S 02744 AND 03838.

Superseded









| | | | | | | | |
|---------------------|-------------|----------|-----------|---|--|---|---------------|
| 7 | C | 646.9712 | I | | BODY (U CHANNEL) | 1 | 2/9 |
| | C | 646.9702 | | | CUTTER SUB ASSY (U CHANNEL) | | |
| F/N TC | PART NUMBER | | 9702.9701 | QTY | DESCRIPTION | MATERIAL | SPECIFICATION |
| DOCUMENTS EFFECTED: | | | | | | | |
| | | | | <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM | CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR | DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO | |

| REVISIONS | | | |
|-----------|-------------------------------------|----------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |
| | LAST PROTOTYPE REVISION: PR2 | | N/C |
| N/C | INITIAL RELEASE | 05/29/09 | P. BRAVO |
| A | INCORPORATED ECN 02744, 03838 03912 | 06/06/13 | P. BRAVO |

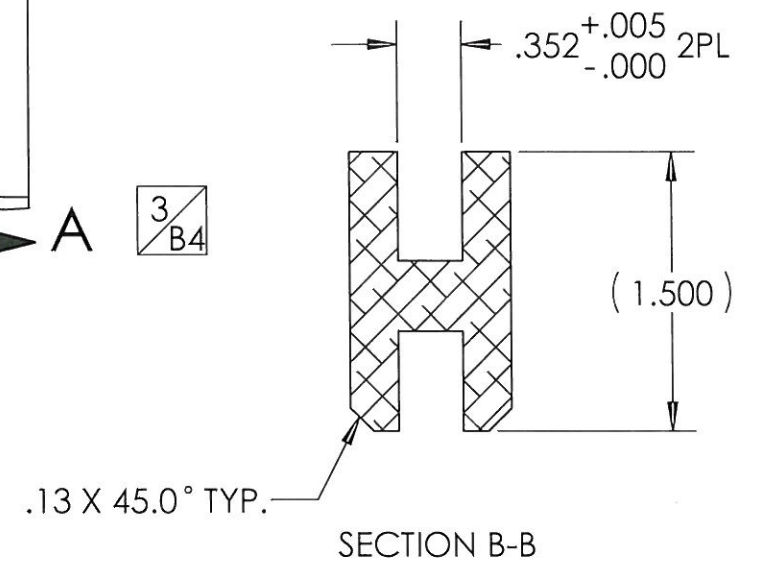
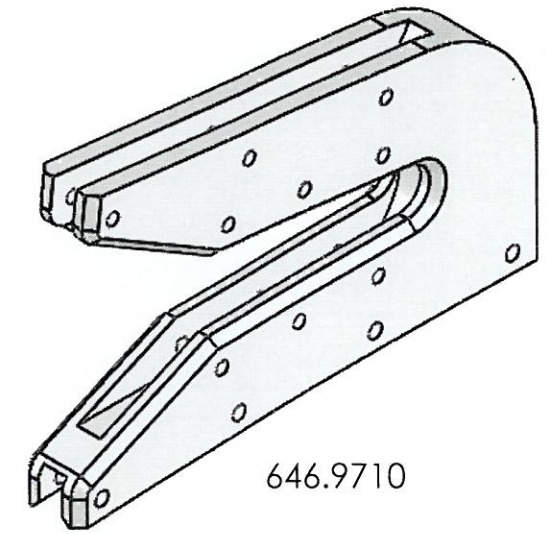
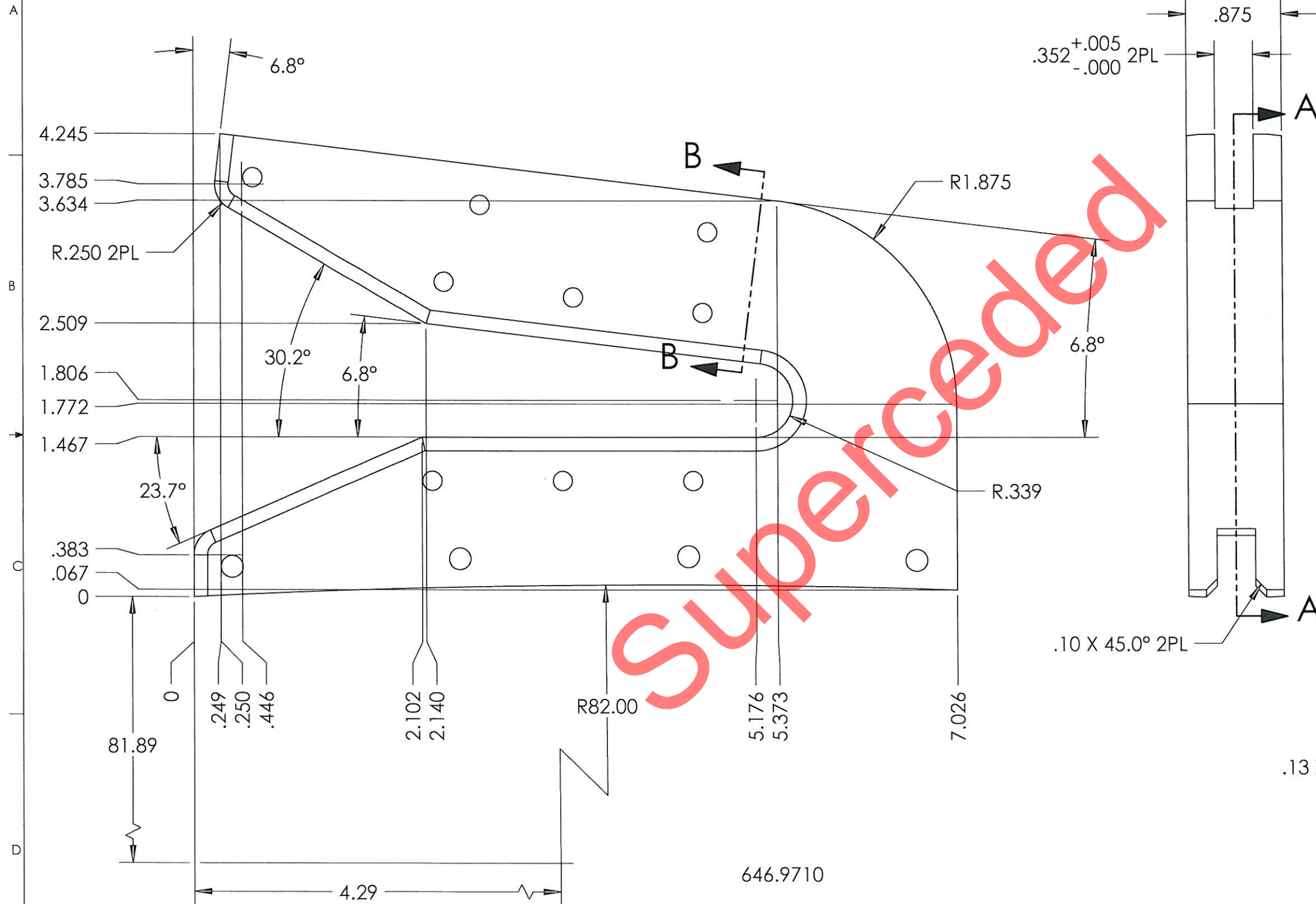
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701
or
646.9702

| | | | | | | | |
|--|---|------|--------|---|-----------------------------|---|---|
| | 1 | | 7 | 646.9712 | BODY (U CHANNEL) |  |  |
| | 6 | 6 | 6 | 601.1541 | LOCKNUT | MS21042L08 | |
| | A/R | A/R | 5 | 601.2764 | RTV, LOCTITE 598 | | |
| | 12 | 12 | 4 | 601.2764 | WASHER | NAS1149FN832P | |
| | 6 | 6 | 3 | 601.2765 | SCREW | MS27039-0819 | |
| | 2 | 2 | 2 | 646.9711 | BLADE |  |  |
| | | 1 | 1 | 646.9710 | BODY |  |  |
| |  | | | 646.9702 | CUTTER SUB ASSY (U CHANNEL) | | |
| |  | | | 646.9701 | CUTTER SUB ASSY | | |
| | 9702 | 9701 | FIND # | PART # | DESCRIPTION | MAT'L | SPEC. |
| QTY | | | | PARTS LIST | | | |
| NEXT ASSY (S) | | | | ORIGINAL DATE (MO-DA-YR) 05-29-09 DRAWN BY P. ROSANO | | CHECKER P. BRAVO | |
| 646.9600 | | | | DRAWING APPROVAL P. BRAVO 05-29-09 | | <div> APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 </div> <div> CUTTER SUB ASSY </div> | |
| 646.9700 | | | | CONTRACT No. | | | |
| | | | | | | | |
| | | | | | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES | | | | SIZE B | CAGE CODE 07MZ6 | DWG. NO 646.9700 | REV. A |
| | | | | SCALE NONE | | SHEET 1 OF 6 | |

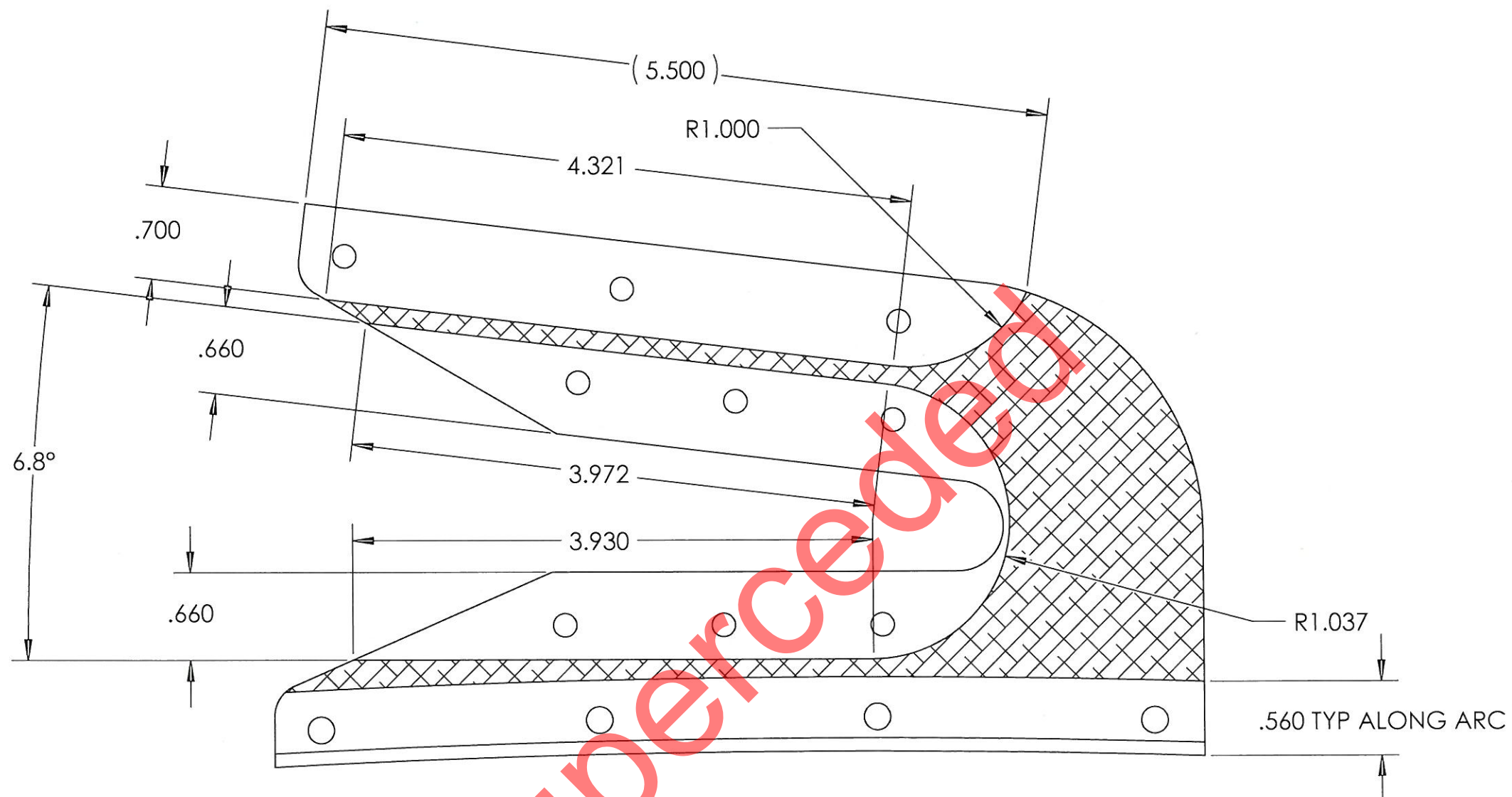
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| ORIGINAL DATE (MO-DA-YR) 05-29-09 | | APICAL INDUSTRIES | |
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| DRAWING APPROVAL P. BRAVO | | CUTTER SUB ASSY | |
| CONTRACT No. | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 5° | | SIZE B | REV. A |
| | | CAGE CODE 07M26 | DWG. NO. 646.9700 |
| | | SCALE: NONE SHEET 2 OF 6 | |

1 2 3 4 5 6 7 8

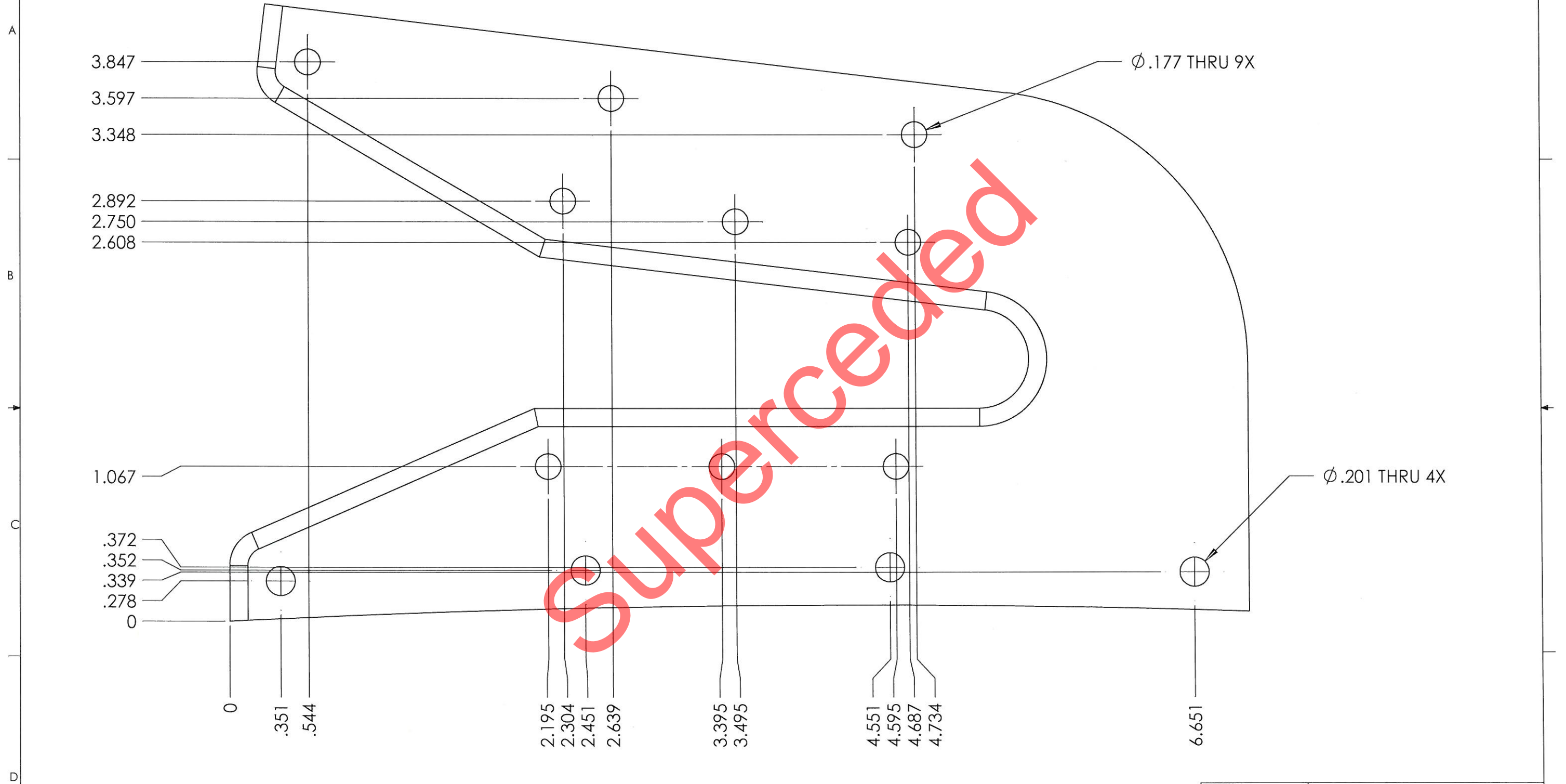
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| SCALE NONE | | | |

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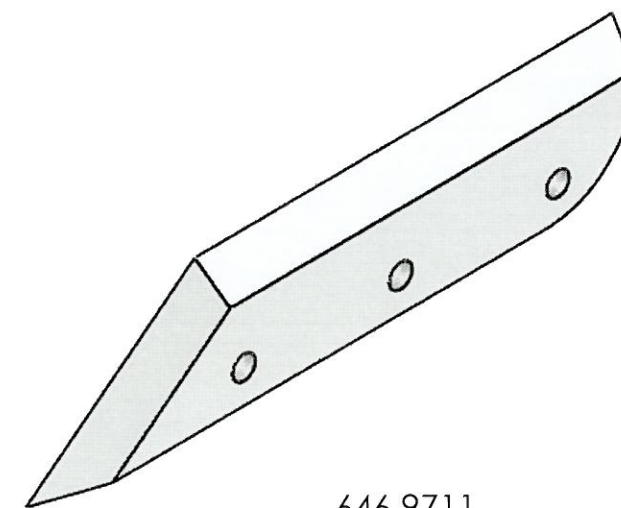
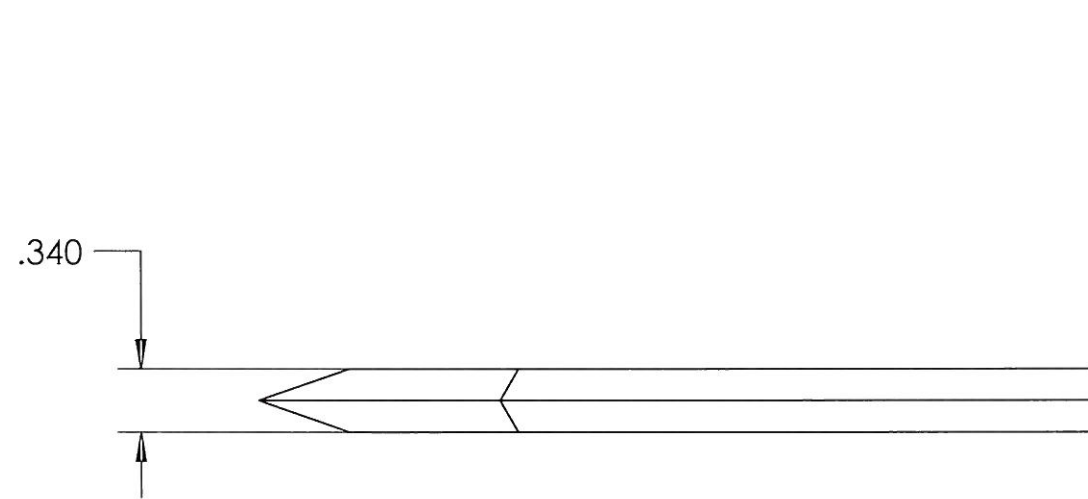
HOLE LOCATIONS +/- .002

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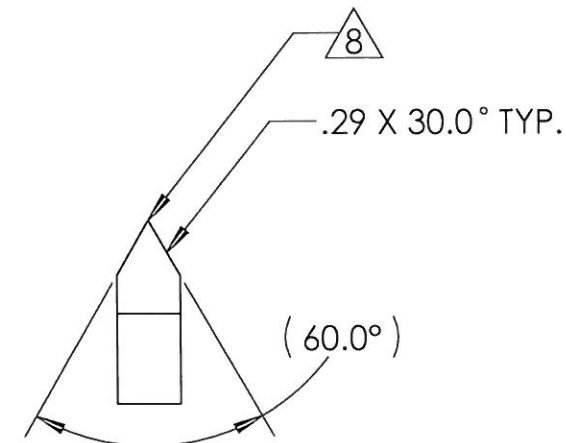
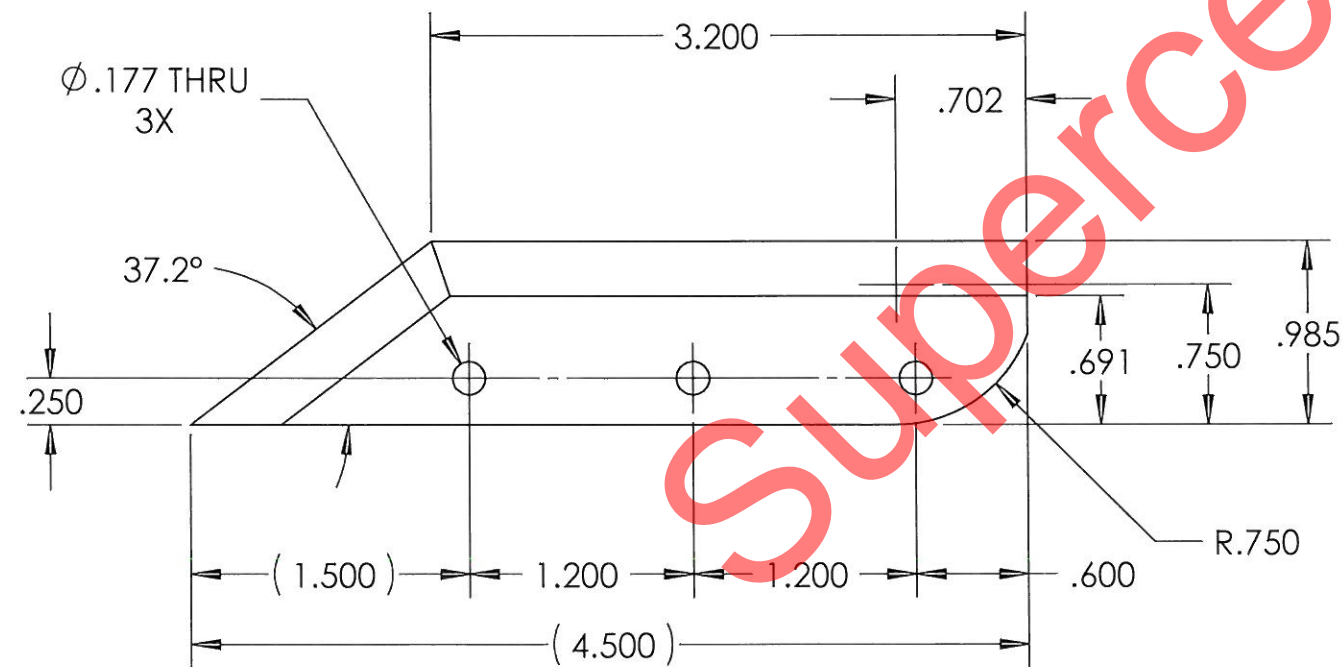
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| | | SCALE NONE | SHEET 4 OF 6 |

1 2 3 4 5 6 7 8

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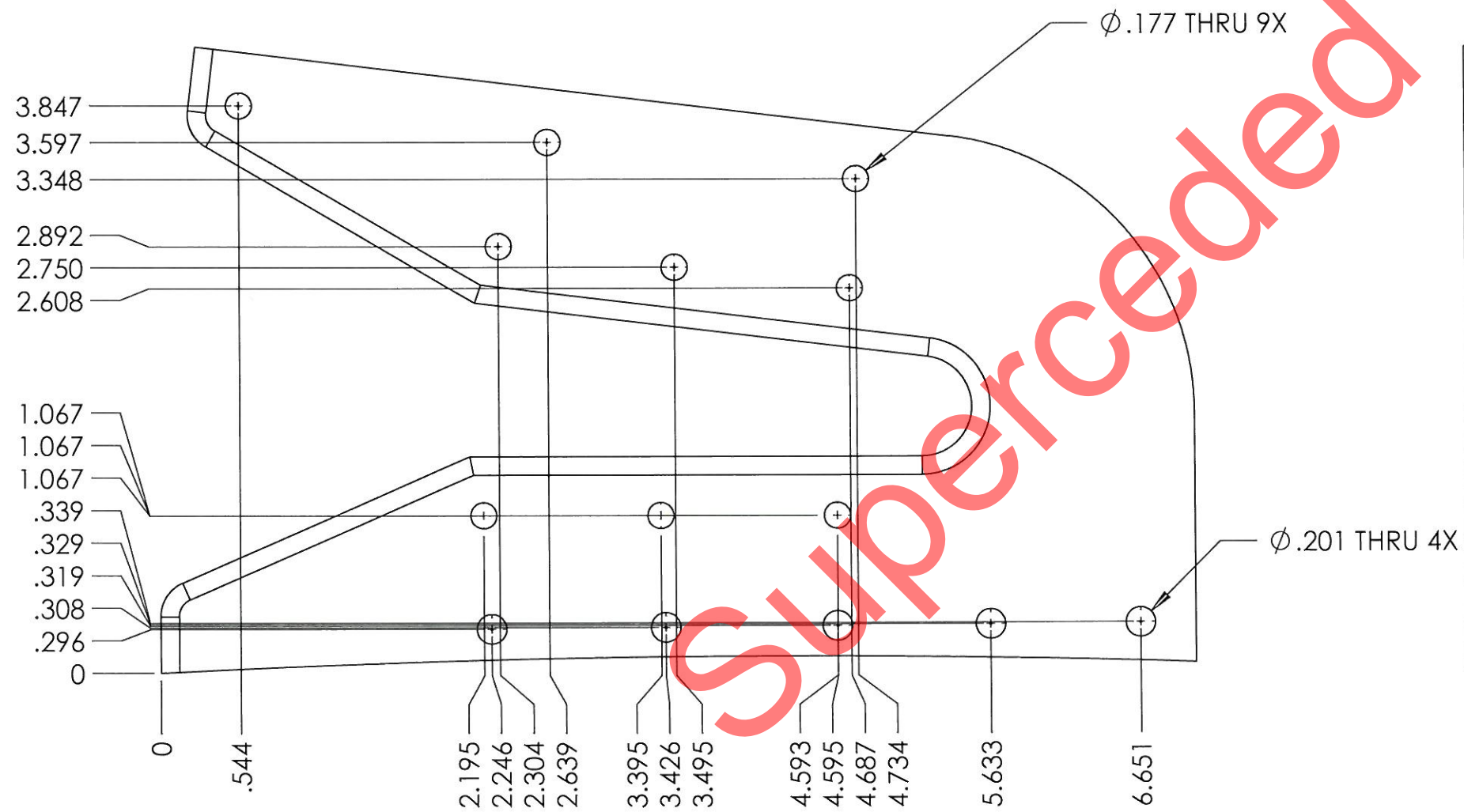
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| DRAWN BY R. ROSANO | CHECKER P. BRAVO | | |
| DRAWING APPROVAL P. BRAVO 05-29-09 | | CUTTER SUB ASSY | |
| CONTRACT No. | | | |
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| | | CAGE CODE 07MZ6 | DWG. NO. 646.9700 |
| | | SCALE NONE | SHEET 5 OF 6 |

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| CONTRACT No. | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$ | | SIZE B | REV. A |
| | | CAGE CODE 07MZ6 | DWG. NO. 646.9700 |
| SCALE NONE | | SHEET 6 OF 6 | |